



U.S. DEPARTMENT OF ENERGY
WORK BREAKDOWN STRUCTURE DICTIONARY
PART II - ELEMENT DEFINITION

1. PROJECT TITLE/PARTICIPANT Environmental Management/Bechtel Jacobs Company LLC		2. DATE 01/08/2004	3. IDENTIFICATION NUMBER DE-AC05-98OR22700
4. WBS ELEMENT CODE 1.12.05.60.09.02		5. WBS ELEMENT TITLE UF6 Cylinder Storage	
6. INDEX LINE NO.	7. REVISION NO. AND AUTHORIZATION N/A		8. DATE N/A
9. APPROVED CHANGES N/A			
10. SYSTEM DESIGN DESCRIPTION			11. BUDGET AND REPORTING NUMBER
12. ELEMENT TASK DESCRIPTION WBS GRAPHIC See attached. INTRODUCTION The mission of UF6 Cylinder Project is to maintain safe long-term storage of the existing UF6 cylinder inventory until its eventual disposition. (The inventory currently consists of 18,945 cylinders). The primary objective of the UF6 Cylinder Project is to implement the requirements of the Ohio Environmental Protection Agency Director's Final Findings and Orders (DFF&O's) dated February 24, 1998, the Defense Nuclear Facilities Safety Board Recommendation 95-1 (Improved Safety of Cylinders Containing Depleted Uranium Hexafluoride) and applicable requirements of the Portsmouth Safety Analysis Report. The UF6 cylinder storage facilities are Category II Nuclear facilities as classified in accordance with the requirements of DOE Order 425.1A. LOGIC RELATIONSHIPS Start shipment of ETTP Cylinders to PORTS in FY 2003. All cylinders will be transitioned to DUF6 Cylinder Conversion Facility in March FY 2005 and all further ETTP cylinders shipped to Portsmouth will be in the DUF6 Cylinder Conversion Facility scope. SCOPE DESCRIPTION Release Sites and Facilities Assessments to be completed: None Actions to be completed: None Performance Metrics/Indicators: * Complete 3,887 Annual inspections by 9/30/03 * Complete 3,732 Quadrennial inspections by 9/30/03 * Complete 150 Ultrasonic thickness measurements by 9/30/03 * Complete 18,945 Radiological surveys by 9/30/03. * Clean/Paint cylinder skirts on 1,100 (maximum) normal assay cylinders. * Install new ID tags on 800 cylinders. Past and Future Accomplishments: Past Accomplishments (Prior to FY 2003)			



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12. ELEMENT TASK DESCRIPTION (Continued) Complete ultrasonic wall thickness measurements on 150 cylinders Complete the identification of cylinders for statistical sampling for PCBs Replace cylinder valve packing nut on 100 cylinders Replace cylinder valve port caps on 11 cylinders Monthly monitoring of five cylinder yard outfalls for uranium contaminants and bi-annually for transuranics & PCB's. Install ID tags on 100 cylinders Semi-annual preventive maintenance and inspection of the fire suppression systems installed on the NCH-35s FY 2002 accomplishments: Complete 2,566 required annual cylinder inspections. Complete 4,119 required quadrennial cylinder inspections. Complete yearly radiological surveys on 18,945 cylinders. Complete ultrasonic wall thickness measurements on 150 cylinders. Monthly monitoring of five cylinder yard outfalls for uranium contaminants and bi-annually for transuranics & PCB's. Minor crack repairs of cylinder yards. Semi-annual preventive maintenance and inspection of the fire suppression systems installed on the NCH-35. Implemented new methodology for counting and storage of Radiological (Rad) Survey data yielding efficiencies of approximately 50%. FY 2003 & Outyear planned accomplishments: <table style="width: 100%; border-collapse: collapse;"><thead><tr><th></th><th colspan="2">FY 03</th><th colspan="2">FY 04</th><th colspan="2">FY 05</th><th>PORT</th><th>ETTP Ttl</th><th>PRT</th></tr><tr><th>ETTP Ttl</th><th>PRT</th><th>ETTP Ttl</th><th></th><th></th><th></th><th></th><th></th><th></th><th></th></tr></thead><tbody><tr><td>Rcvd ETTP</td><td>0</td><td></td><td>2,100</td><td></td><td></td><td>700</td><td></td><td></td><td></td></tr><tr><td>Ttl Cyl rcvd</td><td>0</td><td></td><td>2,100</td><td></td><td></td><td>2,800</td><td></td><td></td><td></td></tr><tr><td>Annl Insp 3,887</td><td></td><td>3,887</td><td>125</td><td>4,012</td><td>3,887</td><td>263</td><td></td><td>4,150</td><td></td></tr><tr><td>Quad Insp 3,732</td><td></td><td>3,732</td><td>113</td><td>3,845</td><td>3,732</td><td>237</td><td></td><td>3,969</td><td></td></tr><tr><td>Rad Srvys 18,945</td><td></td><td>18,945</td><td>500</td><td>19,445</td><td>18,945</td><td>2,100</td><td></td><td>21,045</td><td></td></tr><tr><td>Ultra Thickns 150</td><td></td><td>150</td><td>150</td><td>300</td><td>150</td><td>150</td><td></td><td>300</td><td></td></tr></tbody></table> FY 2003 specific planned accomplishments: Clean/Paint cylinder skirts on 1,100 (maximum) normal assay cylinders. Install new ID tags on 800 cylinders. Monthly monitoring of five cylinder yard outfalls for uranium contaminants and bi-annually for transuranics & PCB's scope will move to Environmental monitoring. Minor crack repairs of cylinder yards. Yard maintenance activities. Annual and semi-annual preventive maintenance and inspection of the fire suppression systems installed on the NCH-35						FY 03		FY 04		FY 05		PORT	ETTP Ttl	PRT	ETTP Ttl	PRT	ETTP Ttl								Rcvd ETTP	0		2,100			700				Ttl Cyl rcvd	0		2,100			2,800				Annl Insp 3,887		3,887	125	4,012	3,887	263		4,150		Quad Insp 3,732		3,732	113	3,845	3,732	237		3,969		Rad Srvys 18,945		18,945	500	19,445	18,945	2,100		21,045		Ultra Thickns 150		150	150	300	150	150		300	
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9. APPROVED CHANGES N/A			
10. SYSTEM DESIGN DESCRIPTION			11. BUDGET AND REPORTING NUMBER
12. ELEMENT TASK DESCRIPTION (Continued) Perform activities associated with the transfer of a backup NCH-35 Cylinder Stacker/Handler (from BJC-Paducah). Implement new requirements identified in the new Documented Safety Analysis (DSA) BJC/PORTS 409 and Technical Safety Requirements (TSR) BJC/PORTS 437 FY 2004 & Outyear specific planned accomplishments: Install new ID tags on 700 cylinders. Monthly monitoring of five cylinder yard outfalls for uranium contaminants and bi-annually for transuranics & PCB's scope will move to Environmental monitoring. Minor crack repairs of cylinder yards. Yard maintenance activities. Annual and semi-annual preventive maintenance and inspection of the fire suppression systems installed on the NCH-35. Begin receipt and S&M of remaining ETTP cylinders, 2,100 cylinders in FY 04, and 700 cylinders in FY 05. The final ~3,100 will be received starting in March FY 05 under the Conversion Plant scope of work. Continue to perform activities associated with deleasing and utilization of X-745G Cylinder Yard to accept cylinders from ETTP. CID's database maintenance and support. FY 2003 Scope UF6 Cylinder Storage The UF6 Cylinder Storage element includes execution of the UF6 cylinder inspection program, implementation of the UF6 cylinder radiological monitoring program, restacking and relocation of up to (2) cylinders to allow for the repair of leaking cylinder valves identified through the cylinder inspection activity. The WBS also includes required preventive and corrective maintenance associated with the cylinders, cylinder storage yards, and cylinder handling equipment to maintain safe storage of the UF6 cylinder inventory. Objectives of the UF6 Cylinder Storage include: Project management of the UF6 Cylinder Project at Portsmouth is consistent with requirements in the Systems Engineering Management Plan (SEMP). The site specific UF6 Cylinder Task Leaders provide direction and oversight. Activities include: * Provide project direction; * Monitor and control project performance; * Risk management and oversight; * Work control and accounting; * Work planning and budget, including prioritization; * System integration including interfacing with the client, regulators, and subcontractors; * Performance measurement and reporting; * Technical support; * A project execution plan will be developed for each subproject to communicate to the project team the scope, method of accomplishment, performance criteria and metrics and procurement strategy.			



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12. ELEMENT TASK DESCRIPTION (Continued) * Document control including records management; * Operational assessments to verify compliance; * Maintenance of the project safety basis including performance of USQDs; * Conduct annual NMC&A inventory; * CID management including downloading files for new cylinders, validating data in CID, and providing CID user support, such as training, system maintenance, and enhancements. * Evaluation and planning for receipt of approximately 5,900 cylinders of various sizes from ETPP. Technical support also includes the implementation of new requirements identified in the new Documented Safety Analysis (DSA) BJC/PORTS 409 and Technical Safety Requirements (TSR) BJC/PORTS 437 for the Portsmouth Gaseous Diffusion Plant Cylinder Yards X-745C and X-745E. This includes the following: 1) Development and revision of operating and maintenance procedures (4 new procedures, 13 major revisions, and 45 minor revisions) 2) Flowdown Matrix Impacts, including supporting implementation of processes for management and tracking requirements 3) Review and revision of procedures for USEC Fire Department, Emergency Management, and Plant Shift Superintendent (PSS) groups - also includes PSS mode change tracking and appropriate BJC communications, and development and conduction of annual fire drill to verify Fire Department response capability 4) Nuclear Criticality Safety (NCS) assumption verification flowdown 5) Facility Modifications, Testing, and Implementation impacts, including: appropriate signage, chains,& posts regarding vehicle and fuel restrictions; traffic control barriers (jersey bouncers, assume 34 20-foot barriers) installation along road adjacent to cylinder yard; and Performance/Quality Assurance review of specification in cylinder handler/hauler contract to ensure surveillance requirements are addressed 6) Training development, execution, and certification - 3 training modules needed for DSA, TSR, and General Employee Training (GET), along with conduction of training; TSR, Conduct of Operations, and Certification training for cylinder crew; and applicable training for support personnel 7) Development of Division of Responsibility (DOR) matrix 8) BJC Validation - performance and readiness activities associated with implementation verification that demonstrates readiness of the facility to implement DSA/TSR Field Operations include the Following: Cylinder Handling and Stacking: A primary emphasis of DNFSB Recommendation 95-1 and the OEPA DFF&O's (2/98) is to improve the long-term storage configuration of the existing DOE cylinder inventory. However, conditions periodically develop which require restacking of cylinders within existing yards due to cylinder maintenance identified through the cylinder inspection activity. No relocation/restacking needs have currently been identified. This element provides for all the labor and materials (including cylinder chocks, diesel fuel, PPE clothing and gear, and other miscellaneous items) necessary to implement restacking of these cylinders.			



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10. SYSTEM DESIGN DESCRIPTION			11. BUDGET AND REPORTING NUMBER
12. ELEMENT TASK DESCRIPTION (Continued) <p>This element includes all activities necessary to maintain the cylinders, cylinder yards and associated facilities, and cylinder operating equipment in a safe configuration.</p> <p>Maintenance activities such as cylinder skirt painting are performed on cylinders primarily to prevent release of radiological contamination or to slow the acceleration of corrosion in areas that are prone to corrosion (such as skirt to body crevice). Typical cylinder maintenance activities resulting from the cylinder inspections include replacement of valves, valve port caps, and valve packing nuts, plugs, painting of up to 1,100 (max) cylinder skirts and reattachment/replacement of up to 800 cylinder nameplates.</p> <p>The following cylinder yards and associated roads are maintained under this WBS: X-745-E, C. These yards represent approximately 16.5 acres in total area. Maintenance activities include: mowing and weed control on a monthly basis during the months of April through September; roads and ground maintenance as needed; ice removal as needed from roads and aisle ways during the winter season; monthly collection of trash and debris including storage and disposal of waste; maintenance of cylinder yard electrical and lighting systems; maintenance and clean out of storm water collections systems, installation and maintenance of yard postings and signage; and minor crack repair.</p> <p>Preventive and corrective maintenance will be performed on cylinder handling and support equipment to ensure safety of operations. The Allied Wagner NCH-35 cylinder handler will be maintained in accordance with the preventive maintenance plan developed for the equipment. Semi-annual preventive maintenance and inspection of the fire suppression systems installed on the NCH-35 will be performed.</p> <p>Also included is the disposition of remaining wooden cylinder cradles, which is FY02 carryover scope.</p> <p>Cylinder and Cylinder Yard Surveillance:</p> <p>Implement a cylinder inspection program to record and monitor physical condition and defects of the cylinders. Implement a radiological monitoring program for periodic monitoring of the UF6 cylinders and cylinder yards.</p> <p>This element provides for the execution of the cylinder inspection program and cylinder radiological monitoring program. The cylinder inspection program consists of performing a visual inspection of cylinders to determine their condition relative to established inspection criteria. The inspection criteria focuses on cylinder structural and mechanical integrity, cylinder storage condition, and nuclear material configuration control. Inspections are performed using handheld pen computers and the data is downloaded to the Cylinder Information Data database. Cylinders receive an initial baseline inspection and then are inspected on an annual or quadrennial basis depending on their condition relative to the established inspection criteria.</p> <p>The cylinder yards are periodically monitored and cylinders are monitored annually to detect the presence of radiological contamination. If cylinders are discovered to have contamination above Plant limits the valve or plug is bagged, decontaminated, and the cylinder is placed on a monthly monitoring program. The cylinder remains on the monitoring program until the contamination is satisfactorily controlled or the valve or plug is replaced. The cylinder yards are monitored on a quarterly basis for transuranics.</p>			



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12. ELEMENT TASK DESCRIPTION (Continued) DFF&O/DSA-related Revisions * Perform activities associated with DFF&O negotiations and revision required by the state to receive cylinders from ETP. * Perform activities associated with revisions to Documented Safety Analyses (DSA) for the Cylinder Yards resulting from deactivating and utilization of X-745G * Develop AHA's, Work Smart Standards crosswalk, NSCA/NCSE, and applicable procedures and permits * Perform resolution activities with USEC regarding shared site issues ETTP Cylinder Receipt/S&M Begin preparatory activities for receipt and storage of approximately 2,800 cylinders from ETP (see above receipt schedule). This element includes: * Update procedures and training and NCSA preparation for unloading and handling cylinders Perform activities associated with deactivating and utilization of X-745G Cylinder yard to accept cylinders from ETP (this also includes establishment of a DMSA, if required) Perform activities associated with the transfer of a backup NCH-35 Cylinder Stacker/Handler (from BJC-Paducah). FY 2004 and out Scope UF6 Cylinder Storage The UF6 Cylinder Storage element includes execution of the UF6 cylinder inspection program, implementation of the UF6 cylinder radiological monitoring program, restacking and relocation of up to (2) cylinders to allow for the repair of leaking cylinder valves identified through the cylinder inspection activity. The WBS also includes required preventive and corrective maintenance associated with the cylinders, cylinder storage yards, and cylinder handling equipment to maintain safe storage of the UF6 cylinder inventory. Objectives of the UF6 Cylinder Storage include: Project management of the UF6 Cylinder Project Portsmouth is consistent with requirements in the Systems Engineering Management Plan (SEMP). The site specific UF6 Cylinder Task Leaders provide direction and oversight consistent. Activities include: * Provide project direction; * Monitor and control project performance; * Risk management and oversight; * Work control and accounting; * Work planning and budget, including prioritization;			



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12. ELEMENT TASK DESCRIPTION (Continued) Technical Support Activities include: <ul style="list-style-type: none">* Maintenance of project procedures and training of personnel on those procedures;* Implementation and maintenance of ISMS including WSS;* Implement configuration change control plan for the Project;* Document control including records management;* Operational assessments to verify compliance;* Maintenance of the project safety basis including performance of USQDs;* Conduct annual NMC&A inventory;* CID management including downloading files for new cylinders, validating data in CID, and providing CID user support, such as training, system maintenance, and enhancements.* Technical assessment of condition of cylinders, prioritization, and defect codes Field Operations include the Following: Cylinder Handling and Stacking: A primary emphasis of DNFSB Recommendation 95-1 and the OEPA DFF&O's (2/98) is to improve the long-term storage configuration of the existing DOE cylinder inventory. However, conditions periodically develop which require restacking of cylinders within existing yards due to cylinder maintenance identified through the cylinder inspection activity. No relocation/restacking needs have currently been identified. This element provides for all the labor and materials (including cylinder chocks, diesel fuel, PPE clothing and gear, and other miscellaneous items) necessary to implement restacking of these cylinders. Cylinder, Cylinder Yard, and Cylinder Equipment Maintenance: Perform preventive and corrective maintenance on the cylinders, cylinder yards, and cylinder handling equipment. This element includes all activities necessary to maintain the cylinders, cylinder yards and associated facilities, and cylinder operating equipment in a safe configuration. Maintenance activities are performed on cylinders primarily to prevent release of radiological contamination or to slow the acceleration of corrosion in areas that are prone to corrosion (such as skirt to body crevice). Typical cylinder maintenance activities resulting from the cylinder inspections include replacement of valves, valve port caps, and valve packing nuts, plugs, and reattachment/replacement of up to 700 cylinder nameplates. The following cylinder yards and associated roads are maintained under this WBS: X-745-E, C & new cylinder yard. These yards represent approximately 16.5 acres plus the approximate 7 acre area of the new cylinder yard. Maintenance activities include: mowing and weed control on a monthly basis during the months of April through September; roads and ground maintenance as needed; ice removal as needed from roads and aisle ways during the winter season; monthly collection of trash and debris including storage and disposal of waste; maintenance of cylinder yard electrical and lighting systems; maintenance and clean out of storm water collections systems; installation and maintenance of yard postings and signage; and minor crack repair.			



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10. SYSTEM DESIGN DESCRIPTION			11. BUDGET AND REPORTING NUMBER
12. ELEMENT TASK DESCRIPTION (Continued) NCH-35 will be performed. Cylinder and Cylinder Yard Surveillance: Implement a cylinder inspection program to record and monitor physical condition and defects of the cylinders. Implement a radiological monitoring program for periodic monitoring of the UF6 cylinders and cylinder yards. This element provides for the execution of the cylinder inspection program and cylinder radiological monitoring program. The cylinder inspection program consists of performing a visual inspection of cylinders to determine their condition relative to established inspection criteria. The inspection criteria focuses on cylinder structural and mechanical integrity, cylinder storage condition, and nuclear material configuration control. Inspections are performed using handheld pen computers and the data is downloaded to the Cylinder Information Data database. Cylinders receive an initial baseline inspection and then are inspected on an annual or quadrennial basis depending on their condition relative to the established inspection criteria. The cylinder yards are periodically monitored and cylinders are monitored annually to detect the presence of radiological contamination. If cylinders are discovered to have contamination above Plant limits the valve or plug is bagged, decontaminated, and the cylinder is placed on a monthly monitoring program. The cylinder remains on the monitoring program until the contamination is satisfactorily controlled or the valve or plug is replaced. The cylinder yards are monitored on a quarterly basis. Ultrasonic wall thickness measurements on cylinders are periodically obtained as input into a statistical based model to help determine corrosion rates within the cylinder inventory. The data provides critical information in relation to breached cylinder predictions, code compliance, and preventive measurement requirements. ETTP Cylinder Receipt/S&M Begin S&M, receipt and storage of cylinders from ETTP based on above receipt schedule. This element includes: * Procurement of 2,800 cradles * Construction and materials for two (2) truck trailer platforms for receipt of cylinders * Relocation of cylinders from off-loading location to Cylinder Yard * Radiological surveys of incoming cylinders * Maintenance support for installation of cradles for cylinder receipt and allowance for one breached cylinder repair per year * Monthly gravel road repairs from loading/unloading of cylinders Continue to perform activities associated with deleasing and utilization of X-745G Cylinder yard to accept cylinders from ETTP (this also includes establishment of a DMSA, if required)			

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12. ELEMENT TASK DESCRIPTION (Continued) <p> s </p> <p> REQUIREMENTS/DRIVERS </p> <p> Bechtel Jacobs Company LLC Contract DE-AC05-98OR22700, December 18, 1997 Integrated Safety Management System Description, BJC/OR-87, Revision 2, September 1999 Integrated Safety Management System Description, BJC-GM-1400, Revision 2, October 2001 and Integrated Safety Management System Supplement, BJC-GM-1401, Revision 0, December 2000 List other Requirements/Drivers for the scope of the Subproject (RODs, Permits, Laws) DOE 5480.21 (USQ - Unreviewed Safety Question) DOE 5480.22 (Technical Safety Requirements) DOE 5480.23 (Nuclear Safety Analysis Report) DOE 420.1 (Facility Safety) SAR DOE 10 CFR 830, "Nuclear Safety Management," Subpart B, "Safety Basis Requirements," January 2001 Ohio EPA Director's Final Findings & Orders, February 1998 Facility Authorization Agreement PAAA </p> <p> As applicable, indicate other regulatory-related requirements. CERCLA: Y/N RCRA: Y/N DNFSB: Y/N DOE Orders: Y AEA: Y/N UMTRCA: Y/N State: Y Other: Y/N </p> <p> WASTE VOLUMES </p> <p> Please see attached waste performance metrics, as applicable. </p> <p> PROJECT SCHEDULE </p> <p> Please see attached project summary schedule, and Milestone Status Summary Report. </p> <p> EXECUTION YEAR BASELINE </p> <p> Please see attached Budgeted Cost of Work Scheduled Plan. </p> <p> BASELINE BY YEAR </p> <p> Please see attached Baseline by Year Report. The Baseline by Year Report should by Fiscal Year (for the project </p>			